

Ship July 13

Work Order ID 163211

163211

Page 1

Monday, June 26, 2017 11:22:40 AM

Item ID: D4092-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Maintenance Step Assembly
 Start Date: 6/26/2017 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 6/28/2017 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUN 26 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4092	C ✓

100	Pick Kit	0.00							
1000									
Packaging	Memo	0.00							
Packaging									

110		0.00							
110									
Small Fab	Memo	3.06							
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.20							
Quality Control									

10 JUL 12 2017 DAS 6 9-89

10x 17/07/17 DAS 36 9-89

10 JUL 17 2017 DAS 38 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
240								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

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163211

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>Pkg</u>	0.00							
130									
Packaging	Memo	0.10							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.00							
Quality Control									

W 9-89
DAS 6-89

JUL 17 2017

17/7/18 JF

DAS
21
9-89

JUL 17 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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OTHER : ☐									

Picklist Print

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Page 1

Work Order ID: 163211

163211

Parent Item: D4092-041

D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 6/26/2017

Required Date: 6/28/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD IPP
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 *D4092-1* Maintenance Step		Manufactured	No			100	Each	5.0000	2	20		JUL 12 2017	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST450				5					
					158631			5					
D4093-1 *D4093-1* Bracket		Manufactured	No			100	Each	6.0000	1	10		JUL 12 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST449				6					
					151603			2					
					155107			4					
D4093-3 *D4093-3* Bracket		Manufactured	No			100	Each	7.0000	1	10		JUL 12 2017	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST449				7					
					151604			3					
					155266			4					
D4093-5 *D4093-5* Bracket		Manufactured	No			100	Each	10.0000	2	20		JUL 12 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST078				10					
					158560			10					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Picklist Print

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Work Order ID: 163211

163211

Parent Item: D4092-041

D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 6/26/2017

Required Date: 6/28/2017

Start Qty: 10.00

Required Qty: 10.00

MS24694-S54

Purchased

No

100

Each

46.0000

2

20

MS24694-S54

SCREW

**

JUL 12 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST284

46

153846

46

MS24694-S55

Purchased

No

100

Each

160.0000

8

80

MS24694-S55

Screw

**

JUL 12 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST283

160

153847

160

MS24694-S56

Purchased

No

100

Each

66.0000

2

20

MS24694-S56

SCREW

**

JUL 12 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST283

66

m135766

66

NAS1149D0332J

Purchased

No

100

Each

952.0000

12

120

NAS1149D0332.J

Washer

**

JUL 12 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

FP

211

m136015

8

m137075

203

GA

272

m136643

272

ST264

469

m136015

0

m137736

469

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID: 163211

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Parent Item: D4092-041

D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 6/26/2017

Required Date: 6/28/2017

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

100

Each

1,655.000

12

120

MS21042L3

Nut

JUL 12 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

79

m135945

79

GA

394

m134360

102

M136665

292

OVER007

500

m134360

0

m137886

500

ST303

682

m137680

682

100

20

DQA: _____ Date: _____

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Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																